

Work Order ID 63136

Page 1

Thursday, October 21, 2010 2:31:41 PM

Item ID: D3927-1

Accept



Setup Start



Revision ID:

Item Name: Guard

Stop



Start Date: 10/22/2010 Start Qty: 7.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: 10-10-21 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3927	B	

100



Waterjet

Memo

0.00

10-10-21

FLOW CNC Waterjet

Cut Blank as file D3927-1_Bank

110



HAAS I

Memo

0.00

7 8

HAAS CNC vertical machine #1

HAAS

0.00

*B.A 10/11/02*1-Mill as per folio FA & dwg D,
FOLIO REV: B
DWG REV: B

2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63136

Page 2

Thursday, October 21, 2010 2:31:41 PM

Item ID: D3927-1

Accept



Setup

Start



Revision ID:

Item Name: Guard

Stop



Start Date: 10/22/2010 Start Qty: 7.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

A.A 10/11/02

7 Ø

130



QC8- Inspect parts - second check

0.00

QC

Quality Control

ark 10/11/04

7 Ø

140

Identify as per dwg & Stock Location: Q6

0.00

Packaging

Packaging

Memo

0.00

10/11/04 sl (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63136

Page 3

Thursday, October 21, 2010 2:31:41 PM

Item ID: D3927-1

Accept



Setup Start



Revision ID:

Item Name: Guard

Stop



Start Date: 10/22/2010 Start Qty: 7.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/05

MF

10-N-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, October 21, 2010 2:31:41 PM

Work Order ID: 63136



Parent Item: D3927-1



Parent Item Name: Guard

Start Date: 10/22/2010

Required Date: 10/29/2010

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP RevA: New issue DD verified by:EC
10.10.21 as per revB DD verified by:

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINB1.000X04.00		Purchased	No			100	f	45.6000	1.36	10.02105			

00



Delrin Bar



10-10-26

Location	Loc Qty	Loc Code
MAT050	45.6	
111695	6	
112665	39.6	

$$\begin{array}{l} \underline{111695} \times 4 = 5.44 \\ \underline{112665} \times 3 = 4.08 \\ \hline 9.52 \end{array}$$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63136
Description: GUARD	Part Number:	D3927-1
Inspection Dwg: D3927 Rev: B		Page 1 of 1

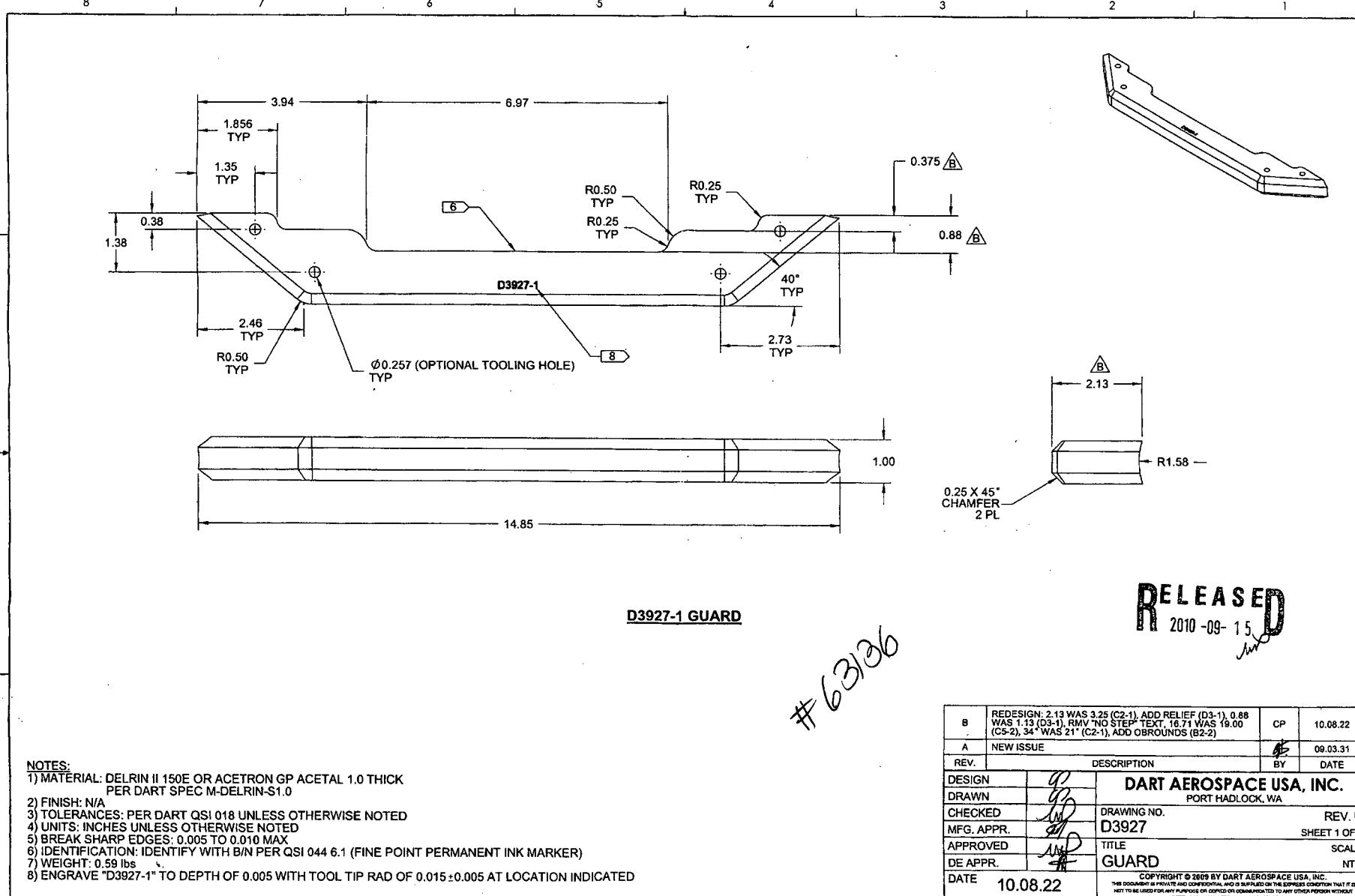
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/- .030	1.370	✓		H-G	31006
0.38	+/- .030	0.375	✓		"	"
1.35	+/- .030	1.347	✓		"	"
1.856	+/- .010	1.856	✓		Vern	GA-01
3.94	+/- .030	3.940	✓		"	"
6.97	+/- .030	6.970	✓		Vern	CNC-02
R 0.50	+/- .030	R 0.500	✓		R.G	ref.
R 0.25	+/- .030	R 0.250	✓		"	"
0.375	+/- .010	0.375	✓		H-G	AM 31006
0.88	+/- .030	0.880	✓		"	"
40°	+/- ½ °	40°	✓		Angle meter	CNC-03
2.73	+/- .030	2.728	✓		H-G	31006
14.85	+/- .030	14.850	✓		TAPE	GA-12
1.00	+/- .030	1.022	✓		Vern	GA-01
2.13	+/- .030	2.126	✓		H-G	31006
0.25x45°	+/- .030	0.253x45°	✓		Vern	GA-01
R 1.58	+/- .030	R 1.580	✓		R.G	ref.

Measured by:	M.A	Audited by:	<i>Amf</i>	Preliminary Approval:	
Date:	10/11/02	Date:	10/11/04	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



B	REDESIGN: 2.13 WAS 3.25 (C2-1), ADD RELIEF (D3-1). 0.88 WAS 1.13 (D3-1), RMV "NO STEP" TEXT. 16.71 WAS 19.00 (C5-2), 34° WAS 21° (C2-1), ADD OBSCOUNDS (B2-2)	CP	10.08.22
A	NEW ISSUE	BY	09.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	100		
DRAWN	93		
CHECKED	1M		
MFG. APPR.	SD	REV. B	
APPROVED	1ND	SHEET 1 OF 2	
DE APPR.	1ND	TITLE	SCALE
DATE	10.08.22	GUARD	NTS

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries